



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18601
Job Sheet 190770



Part No: RBT18601

Job Qty: 5 ea

Part Name: Main Rotor Swashplate ReGreasing Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/14/19

Job Tracking No:

Due Date: 2/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18601 Rev 1C IPP Rev.A 17.09.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Omax - 1	5 pcs	2/18/19	2/18/19	0.00	0.50	Waterjet - Omax		02/19/2019
130	CNC Vertical Machining	5 pcs	2/18/19	2/18/19	0.00	5.00	NV5000-1		J.C.L.
140	QC	5 pcs	2/18/19	2/18/19	0.00	0.00	QC2 Machining-4		J.C.L. 19-03-07
150	QC	5 pcs	2/18/19	2/18/19	0.00	0.00	QC8 Machining-4		B.O. 19-03-21
170	Outsource	5 pcs	2/18/19	2/18/19			ATG001-VC	5	03/22/2019
180	Packaging	5 pcs	2/18/19	2/18/19	0.00	0.00	Packaging2		MAR 29 2019
190	QC	5 pcs	2/18/19	2/18/19	0.00	0.00	QC6		APR 01 2019
200	Small Fab	5 pcs	2/18/19	2/18/19	0.00	1.25	Small Fab-7		M.L.L. 9-80A
210	QC	5 pcs	2/18/19	2/18/19	0.00	0.00	QC5		APR 02 2019
220	Packaging	5 pcs	2/18/19	2/18/19	0.00	0.00	Packaging3-1		M.L.L. 9-80
230	QC21-FG	5 Ea	2/18/19	2/18/19	0.00	0.00	QC21		21 APR 03 2019

Part Op 110 - Waterjet 2 OMAX (Waterjet 2) 1-Cut blanks ***CUT QTY2 PER ASSEMBLY*****Identify each pair as per notes***
 Descriptions: Dwg Rev: 1C Prog Rev: 1C (Red Barn folder) 2-Deburr if necessary
 130 - 1-Face as required 2-Machine as per DWG. Folio FB658 3-DEBURR ***Identify each pair as per notes***
 170 - -Issue P/O to GROUPE ALTECH; PO _____ -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2
 CLASS-2, Water sealant -Material type; -Certificate of Conformity is required
 200 - Assemble as per DWG and cut packings at split line as per notes.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X07.000	6061T6 Bar 0.500 X 7.000	6 ft (1.2 ea)	110-Waterjet - Omax - 1	5072717
0-345	345 O-Ring	5 Ea (1 ea)	200-Small Fab	3082410
0-353	353 O-Ring	5 Ea (1 ea)	200-Small Fab	37 38 5082411
13-14X3CSC	1/4 - 20 X 3 Socket Gap	10 Ea (2 ea)	200-Small Fab	3156208
15-GF637	1/4-28 45 Deg Short Grease Fitting	10 Ea (2 ea)	200-Small Fab	3156257

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Omax - 1	M6061T6B0.500X07.000	6	1	0
200-Small Fab	0-345	5	12	0
	0-353	5	12	0
	13-14X3CSC	10	15	0
	15-GF637	10	18	0

Part Specifications

Specifications could not be found.

Plex 2/14/19 11:42 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S153882



Part: RBT18601

Job No: 190770

Serial No/Batch: S153882

Revision: 1C

Inspector:

Exp Date:

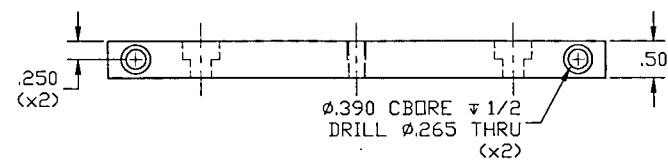
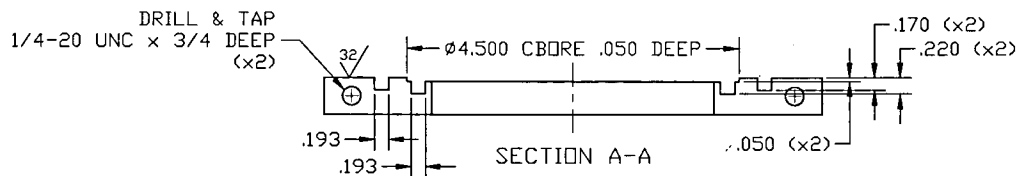
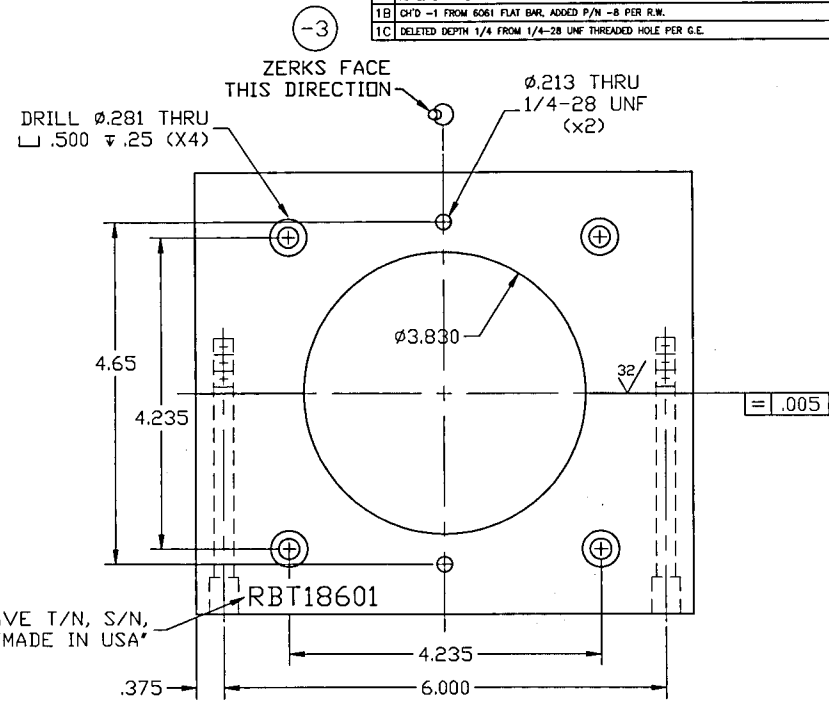
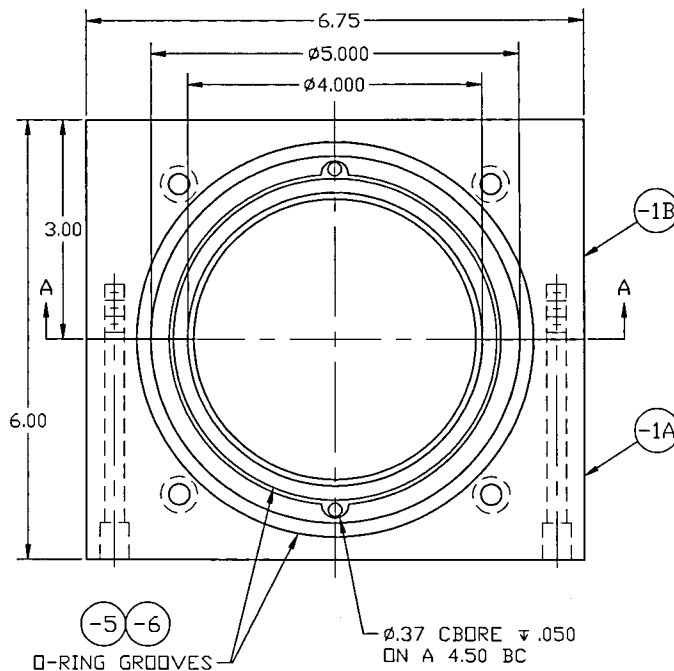
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/14/19

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED ZERK DIRECTION & CHANGE FROM 3-1/4 SHCS.	11/27/04		
1A	CH'D TITLEBLOCK & REVISION BLOCK, CH'D REVISIONS FROM ALPHABETICAL TO NUMERICAL, ADDED ENGRAVE NOTE -1A.	1/13/10	RJC	RW
1B	CH'D -1 FROM 6061 FLAT BAR, ADDED P/N -8 PER R.W.	8/23/11	RJC	RW
1C	DELETED DEPTH 1/4 FROM 1/4-28 UNF THREADED HOLE PER G.E.	5/23/12	RJC	GE



- NOTES:
1. IDENTIFY EACH PAIR.
 2. ASSEMBLE & CUT PACKINGS AT SPLIT LINE.

ASSY QTY	B/D PART	QTY	DESCRIPTION	MATERIAL	B/D INFORMATION OR SPECIFICATIONS
	-1	2	SWASH PLATE	6061 FLAT BAR	1/2 x 3 x 6-3/4
	B/D -3	2	ZERK		1/4-28 UNF x 45°
	B/D -5	1	O-RING	2-345N70 345	BUNAN
	B/D -6	1	O-RING	2-353N70 353	BUNAN
	B/D -8	2	SOCKET HEAD CAP SCREW		1/4-20 UNC x 3

RED BARN MACHINE	
TITLE SWASH PLATE REGREASING TOOL	
DWG NO. RBT18601	REV 1C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES IN DECIMALS XXX ± .005 XX ± .01 X ± .05	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.05 ± .005 PER 0.05 R 2. DIMENSIONAL UNITS APPLY AFTER PLATING	
SCALE NTS	DATE 3-16-01
SHEET 1 of 1	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042956



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042956
PO Date: 3/22/19
Due Date: 3/29/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189182	RBE000-117-9	Plate -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed - X4		3/29/19	4 pcs	0 pcs	4 pcs	\$4.45/pcs	\$1780
***** RUSH ***** RUSH ** NEED BACK MARCH 28,2019 ** MAR 29 2019 DP											
2	188112	RBE1X54-176-875	Press Tool -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed - X4		3/29/19	4 pcs	0 pcs	4 pcs	\$4.45/pcs	\$17.80
MAR 29 2019 DP											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042956



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	188718	RBWA353A04-01	Cap -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL - Certificate of Conformity is required	Firmed	-	3/29/19	5 pcs	0 pcs	5 pcs	\$4.45/pcs	\$22.25
Line Item Note ** need back March 29,2019 **											
	190651			Firmed	-	3/29/19	4 pcs	0 pcs	4 pcs	\$4.45/pcs	\$17.80
Sub Total:							9	0	9		\$40.05
4	188156	RBEVR-L11-0010-004-B-1	Press -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/29/19	4 pcs	0 pcs	4 pcs	\$4.45/pcs	\$17.80
Line Item Note ** need back March 29,2019 **											
5	189487	RBE1X25-166-857-1	Tube -Issue P/O; -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed	-	3/29/19	6 pcs	0 pcs	6 pcs	\$4.45/pcs	\$26.70
Line Item Note ** need back March 29,2019 **											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042956



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	190652	RBWA353A04-06	Cap (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed -		3/29/19	9 pcs	0 pcs	9 pcs	\$1.68/pcs	\$15.12
Line Item Note ** need back March 29,2019 ** BLACK											
7	191261	HT-900-NC-09B	Filter Housing Outsource4 (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed -		3/29/19	4 pcs	0 pcs	4 pcs	\$1.68/pcs	\$6.72
Line Item Note ** need back March 29,2019 ** BLACK											
8	190735	647.4212	Plate Issue P/O to ATG : 1- Black Anodize as per Dwg 647.4200	Firmed -		3/29/19	10 pcs	0 pcs	10 pcs	\$1.68/pcs	\$16.80
Line Item Note ** need back March 29,2019 ** BLACK											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042956



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
9	191740	RBE350A93-3302-02-1	Handle (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3302- 02-1 Rev. 11 -Certificate of Conformity is required	Firmed -		3/29/19	10 pcs	0 pcs	10 pcs	\$1.68/pcs	\$16.80
Line Item Note ** need back March 29,2019 ** BLACK											
10	192223	SWA6A-700B	Wire Clamp, 1/2 X 1- 3/8 X 1-1/4 -Issue P/O: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed -		3/29/19	39 pcs	0 pcs	39 pcs	\$1.59/pcs	\$62.01
Line Item Note ** need back March 29,2019 ** BLACK											
11	189281	RBE703A95-0505-00-1	Quill -Issue P/O: PO -ANODIZE COLOR RED, PER IAW MIL- A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE703A95-0505- 00-1 Rev. 9 -Certificate of Conformity is required	Firmed -		3/29/19	22 pcs	0 pcs	22 pcs	\$1.59/pcs	\$34.98
Line Item Note ** need back March 29,2019 ** RED											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042956



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
12	191749	RBE350A94-3700-C-05	Bottom -Issue P/O: PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBE350A94-3700-C-05 Rev. 6 -Certificate of Conformity is required	Firmed -		3/29/19	34 pcs	0 pcs	34 pcs	\$1.59/pcs	\$54.06
Line Item Note ** need back March 29,2019 ** RED											
	189348			Firmed -		3/29/19	10 pcs	0 pcs	10 pcs	\$1.59/pcs	\$15.90
Sub Total:							44	0	44		\$69.96
13	190770	RBT18601	Main Rotor Swashplate ReGreasing Tool -Issue P/O to GROUPE ALTECH; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; -Certificate of Conformity is required	Firmed -		3/29/19	5 pcs	0 pcs	5 pcs	\$1.59/pcs	\$7.95
Line Item Note ** need back March 29,2019 ** RED											
14	191121	RBE332A94-3400-03-10	Block -Issue P/O; -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; 6061T6 -Certificate of Conformity is required	Firmed -		3/29/19	5 pcs	0 pcs	5 pcs	\$1.59/pcs	\$7.95

Plex 3/25/19 4:09 PM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042956



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Line Item Note	** need back March 29,2019 ** RED										

Grand Total: \$358.44

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/25/19 4:09 PM dart.Lussier.Patrick



Certificat de Conformité / Certificate of Compliance



0 1 7 9 3 6 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

017936- 1

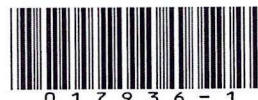
Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
28-Mar-2019		Shankar Anand		042956					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBE000-117-9 Rev.	RBE000-117-9 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4	0	0	0	
2	RBE1X54-176-875 Rev.	RBE1X54-176-875 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4	0	0	0	
3	RBWA353A04-01 Rev.	RBWA353A04-01 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-8625F TYPE 2 CLASS 1	ANODIZE CH	9	9	0	0	0	
4	RBEVR-L11-0010-004-B-1 Rev.	RBEVR-L11-0010-004-B-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	4	4	0	0	0	
5	RBE1X25-166-857-1 Rev.	RBE1X25-166-857-1 01 -ANO-CLEAR [ANODIZE CLEAR] MIL-A-8625F TYPE 2 CLASS 1	ANODIZE CH	6	6	0	0	0	
6	RBWA353A04-06 Rev.	RBWA353A04-06 01 -ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	9	9	0	0	0	
7	HT-900-NC-09B Rev.	HT-900-NC-09B 01 -ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	4	4	0	0	0	
8	647.4212 Rev.	647.4212 01 -ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	10	10	0	0	0	
9	RBE350A93-3302-02-1 Rev.	RBE350A93-3302-02-1 ANODIZE BLACK PER MIL-A-8625F TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	10	10	0	0	0	
10	SWA6A-700B Rev.	SWA6A-700B 01 -ANO-BLACK [ANODIZE BLACK] MIL-A-8625F TYPE 2 CLASS 2	ANODIZE CH	39	39	0	0	0	
11	RBE703A95-0505-00-1 Rev.	RBE703A95-0505-00-1 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	22	22	0	0	0	
12	RBE350A94-3700-C-05 Rev.	RBE350A94-3700-C-05 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	44	44	0	0	0	


Certificat de Conformité / Certificate of Compliance


0 1 7 9 3 6 - 1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip
017936- 1

Livré à / Ship to

DART AEROSPACE LTD

 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
28-Mar-2019		Shankar Anand		042956				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir Back Order
13	RBT18601 Rev.	RBT18601 01 -ANO-RED [ANODIZE RED] MIL-A-8625 TYPE 2 CLASS2	ANODIZE CH	5	5	0	0	0
14	3400-03-10 Rev.	3400-03-10 01 -ANO-RED [ANODIZE RED] PER IAW MIL-A-8625 TYPE 2 CLASS 2 WATER SEALANT	ANODIZE CH	5	5	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.